

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015246**Date Inspected:** 01-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance Inspector (QAI) Bert Madison was present at Yerba Buena Island in California between the times noted above for observations relative to the work being performed by American Bridge/Fluor Enterprises (AB/F) personnel at the locations noted below.

- 1). OBG Field Splice 1W/2W Welds D1 & D2, Face B
- 2). OBG Field Splice 3W/4W Weld ID: E1 & E2, Face B
- 3). OBG Field Splice 4W/5W Weld B, Face A
- 4). OBG Field Splice 4W/5W Weld ID: E1 & E2, Face B
- 5). OBG Field Splice 3E/4E Weld ID: D1 & D2, Face B

- 1). OBG Field Splice 1W/2W weld ID: D1 & D2, Face B

The QAI periodically observed ABF personnel performing grinding in the existing splice groove to prepare for FCAW-G and also welder Rory Hogan setting up for FCAW.

- 2). OBG Field Splice 3W/4W Weld ID: E1 & E2, Face B

The QAI periodically observed SE QC Inspector Steve McConnel performing Ultrasonic Testing (UT) from the B Face of OBG Field Splice 3W/4W Weld ID: E1 & E2. See photo below. Mr. McConnel utilized the UT Procedure identified as SE-UT-D1.5-CT-100 Rev.4 during the examination of the CJP. The QC technician performed the required longitudinal wave utilizing a 1" diameter transducer for base metal soundness and a .63 x .75 rectangular transducer to perform the shear wave testing during the testing for weld soundness. The UT examination was completed during this shift. At the conclusion of the QC testing the QAI observed that the QC technician noted two (2) rejectable flaws which were marked on the B-face of the groove weld.

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3). OBG Field Splice 4W/5W weld ID: B, Face A

The QAI periodically observed the in process welding of OBG Field Splice 4W/5W weld ID: B, Face A per the Flux Cored Welding (FCAW-G) process in the 3G (vertical) position by ABF welding personnel Xiao Jian Wan (ID 9677). QC Inspector Mike Johnson was present to monitor the progress and verify that the joint fit-up & welding parameters were within the limits established by the approved welding Procedure Specification (WPS) identified as ABF-WPS-D1.5-3040B-3. The work at this location was completed during this shift. The QAI observed that the welding parameters and the final weld appeared to be in general compliance with the contract documents. The weld was not ground flush.

4). OBG Field Splice 4W/5W Weld ID: E1 & E2, Face B.

The QAI periodically observed AB/F personnel installing fit-up gear on the OBG Field Splice 4W/5W Weld ID: E1 & E2, Face B. QC Inspector Jim Cunningham was present to monitor the progress and verify that the joint fit-up was in compliance with contract documents.

5). OBG Field Splice 3E/4E Weld ID: D1 & D2, Face B

The QAI periodically observed SE QC Inspector Jesse Cayabyab performing UT from the B Face of OBG Field Splice 3E/4E Weld ID: D1 & D2. See photo below. Mr. Cayabyab utilized the UT Procedure identified as SE-UT-D1.5-CT-100 Rev.4 during the examination of the CJP. The QC technician performed the required longitudinal wave utilizing a 1" diameter transducer for base metal soundness and a .63 x .75 rectangular transducer to perform the shear wave testing during the testing for weld soundness. The UT examination was not completed during this shift.



### Summary of Conversations:

None of relevance.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammed Fatemi (916) 813 3677, who represents the Office of Structural Materials for your project.

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**Inspected By:** Madison,Bert

Quality Assurance Inspector

**Reviewed By:** Levell,Bill

QA Reviewer